AMS PY-INSTRUCTION No. 910
(Egg Products)-1

EGG PRODUCTS INSPECTORS HANDBOOK

Prepared by

POULTRY GRADING SERVICE

UNITED STATES DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISION

AGRI-WASH

UNITED STATES DEPARTMENT OF AGRICULTURE
Agricultural Marketing Service
Poultry Division
Washington 25, D. C.

AMS PY-INSTRUCTION NO. 910
(Egg Products)-1

ACTION BY: Area Grading Supervisors
Federal-State Grading Supervisors
Egg Products Inspectors

EGG PRODUCTS INSPECTORS HANDBOOK

I PURPOSE

The purpose of this Instruction is to replace AMS PY-INSTRUCTION NO. 910 (Egg Products)-1, "Egg Products Inspectors Handbook," dated March, 1955; AMS PY-Internal Notice No. 31, dated January 30, 1956; AMS PY-Internal Notice No. 40, dated December 4, 1956; and Egg Products Memorandum No. 2, dated June 25, 1956. This instruction outlines the duties of an Egg Products Inspector giving operating procedure, together with the method of preparing reports as shown in the examples included herein.

II AUTHORITY

The authority for this instruction is contained in the Regulations Governing the Grading and Inspection of Egg Products. Citations appearing in this instruction refer to the Regulations Governing the Grading and Inspection of Egg Products.

III POLICY

It is the policy of the Administration to require the supervisor to supply each Egg Products Inspector with a copy of this instruction and that the inspector maintain the instruction on a current basis by adding each amendment as issued by the Administration.

B. W. Kempers, Acting Chief
Grading Branch, Poultry Division

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I EXTENT OF SUPERVISION (INSPECTION)

All egg breaking and egg drying operations in official plants are subject to supervision (§55.77b). It is the responsibility of management to notify the Egg Products Inspector, in advance, (at least the day prior to operation) when egg processing operations will be carried on.

The extent of the official plant is as agreed to and recorded on the approved blueprint. In addition, any condition on the premise which creates a nuisance, harbor for rodents, insects, or undesirable strong off-odor is subject to correction to maintain plant approval.

II DUTIES OF EGG PRODUCTS INSPECTOR, §55.17

A. The duties of a licensed Egg Products Inspector require him to:

1. Make such observations and inspections as are necessary to enable him to certify that egg products have been prepared, processed, stored, and otherwise handled in conformity with the Regulations governing this activity.

   Particularly note the following:

   a. Sanitation of the overall plant and processing rooms.

   b. Selection of raw material in the candling and breaking rooms. Lots of shell eggs containing more than occasional loss (other than bloody whites, green whites, and undetectable sours) must be candled on an individual egg basis prior to placing on a breaking line.

   c. Supervision of the limited licensed inspectors.

   d. Processing temperatures.

2. Call all deviations from the Sanitary Requirements to the attention of the designated company representative and record on Form PY-203, "Daily Report of Plant Operation." There is ample space on the back of these forms to report deviations.

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3. Supervise the marking of all packages containing product which is to bear the official identification.

4. The inspector shall retain in his custody and/or under his supervision, labels with the Department's legend, marking devices, samples, certificates, seals, and official reports.

5. Examine the finished product for:

   a. Quality and condition.

   b. Accuracy of net weight.

6. When requested, select, draw, prepare and ship samples to the laboratory for analyses.

7. Prepare the following reports:

   a. Form PY-203, "Daily Report of Plant Operation".

   b. Form PY-200, "Egg Products Inspection Certificate", When requested by management.

   c. Form PY-206, "Egg Products Inspectors Report", (each month).

8. The inspector shall contact his State Supervisor regarding any frequent recurring deviations from the Regulations; when product is not being frozen properly; or when problems arise not covered by this instruction or the Regulations.

9. Deface or remove or cause to be defaced or removed, under the inspector's personal supervision, the Department's legend from any and all packages containing liquid, frozen or dried eggs or egg products unfit for food, or not processed according to these instructions and the Regulations.

10. Observe that all egg products which are unfit for food are denatured and that shell eggs which are unfit for food are treated in such a manner as will preclude their use as human food. (See §55.75(c), 55.79(g-4, amended), and 55.83(n).

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11. Check the temperature of all cars and trucks which are loaded during normal working hours, both prior to and after loading.

12. If the inspector is sick or unable to be 'on the job', he shall immediately contact his supervisor. A plant cannot operate without an inspector on duty.

III AN EGG PRODUCTS INSPECTOR DOES NOT:

A. Reveal to others any information concerning company equipment, methods of operation, or quality of the product.

B. Assume the duties or authority of the Plant Superintendent or Foreman.

C. Endeavor to settle differences of opinion between the seller of raw materials and the company, or between the company and buyer of the finished product.

D. Become involved in or take any part in discussions concerning the relationships between the company and its employees.

E. Advise the company or company representative on matters which are not specifically covered in the Egg Products Regulations or in this instruction, without first obtaining a ruling from his State Supervisor.

F. Conduct himself in a manner which will reflect a discredit to the United States Department of Agriculture.

G. Use Franked envelopes improperly.

IV FORM PY-203, "DAILY REPORT OF PLANT OPERATION"

The resident inspector must record his true and complete observations on Form PY-203. Company licensed employees are not to be utilized in taking or recording data for official information. It is the resident inspectors duty to make the checks and record these data.

The State Supervisor has limited authority to determine whether there was substantial compliance with the Egg Products Regulations.

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In other words, he may permit the product to be identified if in his discretion there was substantial compliance, and it does not adversely affect the product. The inspector shall request management to initial each PY-203 that reflects substantial deviations from the minimum requirements.

KNOWINGLY FALSIFYING ANY OFFICIAL REPORT IS CAUSE FOR SUSPENSION OF A LICENSE.

The distribution of Form PY-203 is as follows:

1. The original to the State Supervisor (as often as requested).

2. If requested, one copy to the company.

3. One copy to the inspector's files.

See pages 30 to 33 for the explanation and example of Form PY-203.

V IDENTIFICATION

A. Labeling

1. Approval is required for any label whether printed, written, stamped, stenciled, or lithographed which bears the USDA identification. The company is responsible for obtaining the approval. It is the responsibility of the inspector and the company to see that only approved labels are used. It is necessary that the National Office receive three (3) copies of all labeling material for approval. The basis of approval is contained in §55.35.

2. Each Egg Products Inspector shall maintain a file of approved labels (§55.43 and 55.18(b)). He shall request the company to notify the National Office of each set of labels that becomes obsolete or is discontinued.

3. The product which may bear the inspection shield mark is defined in §55.37. The product which may bear the "rectangular mark" is defined in §55.39 and 55.40.

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4. Processing and identification of product must be under the supervision of an Egg Products Inspector. See §55.77, 55.43(b), and 55.17.

5. The lot number referred to in §55.36 and 55.38 may be the day of the year that the product was produced. It may also be a company code date, provided the code is furnished to the Department at the time the company requests label approval. Such codes shall be in a form that will enable the Department to segregate each day's production. The codes used each day shall be recorded on the daily log (PY-203) for that day.

B. Definitions and Standards for Food of the Food and Drug Administration: (Liquid, frozen and dried eggs); Part 10, Sec. 42 - General Regulations Relating to Definitions and Standards for Food.

1. §42.0 Eggs. No regulation shall be promulgated, fixing and establishing a reasonable definition and standard of identity for the food commonly known as eggs.

2. §42.10 Liquid Eggs, Mixed Eggs, Liquid Whole Eggs, Mixed Whole Eggs; Identity. Liquid eggs, mixed eggs, liquid whole eggs, mixed whole eggs, are eggs of the domestic hen, broken from the shells, and with yolks and whites in their natural proportions as so broken. They may be mixed, or mixed and strained.

3. §42.20 Frozen Eggs, Frozen Whole Eggs, Frozen Mixed Eggs; Identity. Frozen eggs, frozen whole eggs, frozen mixed eggs, are the food prepared by freezing liquid eggs.

4. §43.20 Dried Eggs, Dried Whole Eggs; Identity. Dried Eggs, dried whole eggs, are the food prepared by drying liquid eggs. They may be powdered. They contain not less than 92 percent total egg solids, as determined by the method prescribed in "Official and Tentative Methods of Analysis of the Association of Official Agricultural Chemists", Fourth Edition, 1935, Pages 297 and 298 (Ed. Note, 8th Edition, 1955, Page 291) under "Total Solids."

5. §42.40 Egg Yolks, Liquid Egg Yolks, Yolks, Liquid Yolks; Identity. Egg yolks, liquid egg yolks, yolks, liquid

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yolks, are yolks of eggs of the domestic hen so separated from the whites thereof as to contain not less than 43 percent total solids, as determined by the method prescribed in "Official and Tentative Methods of Analysis of the Association of Official Agricultural Chemists", Fourth Edition, 1935, Pages 297 and 298 (Ed. Note, 8th Edition, 1955, Pages 291-292), under "Total Solids". They may be mixed, or mixed and strained.

6. §42.50 Frozen Yolks, Frozen Egg Yolks; Identity. Frozen yolks, frozen egg yolks, are the food prepared by freezing egg yolks.

7. §42.60 Dried Egg Yolks, Dried Yolks; Identity. Dried egg yolks, dried yolks, are the food prepared by drying egg yolks. They contain not less than 95 percent total egg solids, as determined by the method prescribed in "Official and Tentative Methods of Analysis of the Association of Official Agricultural Chemists," Fourth Edition, 1935, Pages 297 and 298 (Ed. Note, 8th Edition, 1955, Pages 291-292) under "Total Solids."

C. Other labeling

1. Inedible Eggs. Inedible eggs may be labeled as such but in addition they shall be denatured in accordance with official instructions, or kept under inventory in accordance with special instructions and permission from the National Office. (See X-B, Page 23.)

2. When whites and yolks are mixed and do not meet the requirements of Item 2, Page 6, they should be labeled "Whites and Yolks." The Regulations require that if they do not contain 25.5 percent egg solids or more, that the percent solids shall be declared on each container.

3. Product which contains turkey, duck, guinea or goose eggs may be labeled "Blended eggs -- turkey, duck, guinea or goose." They may be identified with the Rectangular stamp. See §55.38 and 55.40.

4. Fowl Ova. Fowl ova is ova or shell egg that is removed from a fowl during the evisceration process. They shall

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not be packed under the Egg Products Inspection Mark. The Poultry Grading Branch does not handle fowl ova. These are processed under the supervision of the Poultry Inspection Branch.

5. The term "Main Office" or "General Office", city and state may be used in lieu of local address.

6. Egg Products. Labels shall declare the ingredients by their common name and be listed in descending order, based on volume. When labels are submitted, either the exact formula or a certified statement that they are listed in descending order, must accompany the label.

7. A list of additives approved by the Food and Drug Administration, under the food additives law, is included in 'C-3' of the Egg Products Index. Any additive must appear on the approved label of the product.

VI FINAL QUALITY AND CONDITION EXAMINATION

Final inspection of egg products: All egg products, whether officially identified or not shall, at the completion of the processing operation, be inspected by an inspector to ascertain the condition of the finished product. See §55.83(gg). This is a very important duty. Draw a representative sample; drill only under favorable conditions.

A. Size of Sample and When to Drill

1. Product produced from raw material, described in §55.37.

a. In all plants, except where product is sold in liquid form, the inspector shall determine the quality and condition of the product by drilling that portion which has been in the freezer a maximum of 72 hours. Three percent of the packages, but not to exceed 25 containers of each day's pack, are to be checked in this manner, except when Section VI-A-2-a applies. The samples the inspector select are to be taken from various parts of the lot but must include some from the center of the stack since they are the last to freeze. See §55.88 and Item 3, Page 9.

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b. If the product is frozen in less than 72 hours, the final inspection may be made as soon as the product is frozen.

c. When product is not frozen in 72 hours, the inspector shall contact his State Supervisor immediately. Such product, when carrying the official legend, may only be removed from the plant upon direct instructions from the State Supervisor.

d. When product, such as yolks with 10 percent salt added, is processed, you shall examine a few (at least 5) containers of the product for general condition. If drilling is not possible, a stainless steel trier should be inserted into the center of the can, thrusting same to bottom of the product and removing a plug. Determination of acceptable freeze and condition can then be made.

e. When plain whites are packed, the inspector shall drill one (1) percent but not to exceed five (5) containers, for each day's production.

2. Product produced from raw material, described in §55.39.

a. Product which is eligible to bear the rectangular mark shall be identified at the time of production if said product is to be officially identified. The final inspection shall be performed by the State Supervisor, or person designated by him. The extent of such examination is supplied in Section VI-B-8.

3. Irrespective of the minimum amount the inspector is required to drill for final inspection, as provided for in Section VI-A-1, he is authorized to increase the size of his sample. In particular, he should feel free to increase the size of his sample when the product involved is "whites and yolks", which are packed as a by-product in a separation operation.

B. How to Drill

1. The examination is only to be made in a room with a temperature above 55°F. and free from drafts and objectionable odors.

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2. Drill one hole in the center of the container as nearly perpendicular as possible and to within one inch of the bottom. Use only a high speed electric drill (1200 rpm) equipped with a bit 11/16 inch or larger diameter.

3. Product in any container that is sour, musty, fermented, putrid, moldy, contaminated with foreign material, or shows evidence of any other objectionable odor is considered definitely off-condition and unsatisfactory. Foreign material includes insects, dirt, egg shells, blood spots, and similar material.

4. When any portion of a day's production is found to be unsatisfactory, the inspector shall notify his State Supervisor, who will arrange to have the product segregated on a container-by-container basis.

5. When any day's production is found to contain stale or strong eggy-odored product, or has not been frozen in the required time, the inspector should arrange with the plant management to do any one or more of the following in order to meet the temperature and freezing requirements:

   a. Lower the temperature of the liquid entering the freezer.

   b. Lower the temperature of the freezer.

   c. Space the containers farther apart.

   d. Increase the circulation of air in the freezer.

   e. Reduce the production of liquid so that freezing capacity matches liquid production.

6. The inspector shall notify his State Supervisor promptly of any freezing difficulties when they are encountered.

7. In instances where product is packaged on the premises but freezers are not on the premises, the product shall be checked for adequacy of freezing. A member of the field

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office staff shall check the product when the field office and the freezer are located in the same city. This checkup is not part of the resident supervisory service rendered under the application for service. Therefore, it is necessary to bill for this check-drilling on the basis of time and expenses. Form PY-200, "Egg Products Inspection Certificate", may be used to certify to the condition.

8. The extent of the final examination to be made for rectangular product is left to the discretion of the State Supervisor, or the qualified individual designated by him to perform the final inspection work on such product. The person making the determination shall satisfy himself that his sample is sufficient to enable him to certify that the product in each container in the lot is satisfactory. The adequacy of the sample will be based on such factors as: The season of production, type of operations, continuity of operation, the adequacy of the freezers, or the historical record of the plant. It may mean that when the quantity of the product produced is limited that he will wish to drill each container. On the other hand, there may be seasons of the year or conditions which may cause him to limit his drilling to three (3) percent of the product in carlots, or the square root in lots of less than 1,000 cans.

9. The egg products inspector or egg products grader not regularly assigned to the plant will bill for final inspection on the regular monthly bill, Form PY-165, "Bill for Service Rendered," by inserting his name over the caption "Salaries, Relief Grader-Regular"; he will indicate the number of hours that were required to perform this work.

C. Test Weighing Procedure

The net weights of individual containers are to be checked at regular intervals. In addition, weigh not less than three (3) percent or 15 containers (whichever is the smaller) each day. These containers are to be weighed on a scale other than that used for weighing individual containers. They should be weighed in as large a quantity as practical, preferably 15 at a time. The net is determined by subtracting the weights of the containers (tare) from the total of the gross weights

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obtained. The tare weight of the individual container is obtained by weighing not less than 20 containers from each shipment at the time shipment is received and dividing by the number of containers weighed. Scales used in making official weight test shall be tested for accuracy periodically.

VII SELECTION, PREPARATION AND SHIPMENT OF SAMPLES FOR LABORATORY ANALYSIS

A. Analysis at USDA Laboratories.

1. When a request for laboratory analysis is received after the product is frozen, the inspector shall:

   a. Sterilize the drill bit and spoon. Clean drill chuck with clean dry cloth. Sterilization can be accomplished according to AMS PY-INSTRUCTION NO. 910 (Egg Products)-3, Page 10 (see 'I-1' in Egg Products Index).

   b. Select the square root of the lot for samples in lots of 1,000 or less, and three (3) percent in larger lots. Double stamp all containers which are samples.

   c. Brush to one side, or scoop out with a spoon, all ice crystals from the top surface of the product.

   d. Drill three holes equidistant from the center and the edge of the can. Drill to within one inch from the bottom of the container.

      Bit must be sterilized prior to use and after being in contact with off-condition products or foreign material (in egg meat). Bit and spoon shall be kept from contacting anything other than the shavings being sampled.

   e. Use a sterile spoon and remove a portion of the egg from each of the three (3) piles of shavings.

   f. Handle sterile container as follows:

      (1) Request assistant to handle the container.

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(2) Assistant must wash hands before unwrapping the sterile container.

(3) Remove rubber stopper, screw top cap, or lid without touching that part of stopper or lid which will be in the mouth of the container when it is replaced.

(4) Place sample directly into container.

(5) Replace stopper or cap as soon as sampling is completed.

(6) Fill container as full as possible.

(7) The amount of sample necessary depends upon the analysis desired. Usually one pint to one quart is sufficient. In the case of a 'whip test' for egg whites, approximately 2 pounds are needed.

g. Refreeze sample immediately.

h. Place a label on each sample container, indicating name and address of firm, date processed, type of product, USDA lot number, and analysis desired.

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(  Joe Doe, Miller, Iowa          2/10 to 2/12  )
(              Date Sampled 2/16                )
(  Whole Eggs      USDA   Lot Number  41 - 43    )
(                                               )
(            Direct microscopic -               )
(            Total solids                       )
(               Fat color                       )
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i. Writing directly on a container is not satisfactory. Such writing smears when the product is defrosted.

j. Wrap each bottle or can with paper or cloth.

k. Pack in shipping (insulated) containers. Samples will not be analyzed if they arrive at the laboratory in a defrosted state.

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1. Wrap dry ice with at least four thickness of paper (5 to 15 pounds of dry ice are needed), depending on the time of the year and the time required to deliver the sample.

m. Lots containing unsatisfactory product are not to be sampled for laboratory analysis.

n. Samples for bacterial analysis should be taken before the organoleptic (smell) test is made.

2. When a request is received to draw a sample in liquid form, the inspector shall handle (where applicable) as in A-1 above. Draw a composite sample at a minimum of two intervals throughout the day (one-half in the morning and one-half in the afternoon). Allow one-fourth inch head room for expansion while freezing. A separate sample is to be drawn for each day's production. If analysis is requested on more than one type of product (whole, plain yolks, sugared yolks), a separate sample is to be drawn for each type. Be sure to place the sample in the freezer immediately after you draw each part of the sample.

   Do not ship samples to the laboratory in non-insulated containers or without dry ice wrapped with at least four thicknesses of paper. Do not ship samples that are not frozen solid. The company at which the inspector is stationed should arrange to have dry ice available on the date the samples are to be shipped. They also are expected to furnish durable well-insulated shipping containers and bottles, or cans, which have been sterilized. Delay issuing Form PY-200 when sample is drawn in liquid form until after check-drilling the frozen product.

3. One of the Certificate, Form PY-200, copy sheets shall be executed to the extent possible. This copy of Form PY-200 is to be enclosed with the samples to the USDA laboratory. The certificate may only cover the lot sampled.

4. Indicate on Form PY-200 the method for color determination; i.e., NEPA or B carotene.

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5. Prepare Form PY-200 complete in an original and seven (7) copies and mail original and six (6) copies to Dr. J. L. Dizikes, Dairy Division Laboratory, AMS, 1819 W. Pershing Road, Chicago 9, Illinois. Make sure the copies are stapled together at the top. The laboratory will complete the Form PY-200 and will insert the laboratory analysis results. They will keep two (2) copies and return four (4) copies to the plant, c/o USDA Grader. The seventh copy will be attached to PY-206 and mailed to the State Supervisor. If the completed copies are received from the laboratory before the end of the month, the inspector shall distribute the certificates as required in Section IX-B-1c (1). Other laboratories to which the samples may be sent are: Processed Foods Laboratory, 641 Washington Street, New York 14, New York, or State Laboratory, 110 Bagley Hall, University of Washington, Seattle, Washington. For palatability or Salmonella analyses, the samples must be sent to the Chicago Laboratory.

6. Time the shipment so as not to arrive at the Laboratory on Friday to Sunday, or the day before or on a Holiday.

B. Analysis at Plant Level

If the inspector is licensed to do certain laboratory procedures, these can be done in the plant laboratory and certificates issued.

1. Frozen samples will be handled according to the instructions VII-A-1(a-h). If sample is to be analyzed immediately, refreezing is not necessary.

2. Liquid samples will be obtained according to Section VII-A-2. Certain analysis can be run on liquid samples without freezing (if done immediately). For bacterial analysis, of if the sample is to be stored, the sample shall be frozen, prior to analysis.

3. The Form PY-200 shall be executed as outlined under VII and IX. The licensed grader will, after obtaining the results of the analysis, fill out the applicable laboratory section and sign his name as the official chemist. A dash shall be placed in laboratory sections not applicable.

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4. The Form PY-200 (certificate) will be prepared in an original and six (6) copies and distributed according to Section IX-B-1c(1), except that one copy will be sent to George J. Banwart, Room 1115 U. S. Custom House, 610 South Canal Street, Chicago 7, Illinois.

VIII APPEALS

A. Filing of Appeals. Appeals from the laboratory results, made on any egg products which were officially sampled, should be requested within the prescribed time limit of 48 hours following receipt of the analysis. All appeals must be approved in the National Office (§55.51).

B. Procedures to follow when Laboratory Analysis is Appealed.

1. Extent of Sampling.

Two groups of equal size of sample containers shall be selected. Each group shall equal the number of sample containers drawn in the original inspection. Submit one sample for analysis from each group. Each sample container shall be examined for condition.

2. Reporting Results.

The analyses of both samples shall be reported on the certificate.

3. Interpretation of Results.

In instances when product is examined to determine whether it meets the terms of a contract, the results of both analyses shall meet the required specifications.

C. Procedure to follow when no Laboratory Analysis is Involved.

When an appeal is requested and the original inspection was for condition only, or weight, the appeal sample shall consist of the original sample and an equal number drawn at random.

IX CERTIFYING FINISHED PRODUCT, EGG PRODUCTS INSPECTION CERTIFICATE (FORM PY-200)

Prior to signing this form, the inspector shall read the certifica-

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tion he is signing. Only a complete and correct certificate may be signed. Certificates are to be prepared upon request, and after the product has been examined for condition. They shall be issued in consecutive order. Certificates should be typed. When not typed, they shall be printed in ink or indelible pencil. All copy sheets shall bear the number of the original of which they are copies.

A. Preparation of Certificate.

Date - Insert date of final inspection.
Issued in cooperation with - Obtain from State Supervisor.
Kind of package - Indicate type of material and size; e.g., 30 lb. tin (state if lacquered), or 5 lb. fiber.
Previous package marks - Insert plant number, code number, and whether shield or rectangular mark. (The word 'previous' is not applicable to resident work.)
Type of product - Indicate class and whether frozen, liquid, or dried; e.g., frozen whole eggs. This block is not to be utilized for the statement "Salmonella Free". This term shall never be used on a certificate. If the USDA Laboratory in Chicago analyzes for Salmonella, it will be reported under Laboratory Analysis as "Salmonella Negative".
Place sampled or weighed - Insert Plant Name, Street, City, and State.
Packages were stamped with - Means identification the inspector applied, such as placing a cross in all and insert shield or rectangular or USDA.
To applicant - Insert name of company at which the inspector is stationed.
Name and address of seller - As stated by applicant.
Name and address of buyer - Obtain from applicant.

ORGANOLEPTIC INSPECTION

Lot No. - Insert USDA and when applicable, company lot number.
Date manufactured - Insert date product produced as liquid egg, if product is liquid or frozen. Insert date dried when product is dried.
Remainder of organoleptic items self-explanatory.

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WEIGHING REPORT

Total - Report number of containers, multiplied by marked weight.
Test Shortage - Determine shortage per container and multiply by number of containers in the lot.
Total Net - Difference between marked and shortage. In case there is an overage, marked and net are to be shown as the same and test shortage as none.

Whether a test weight is made or not, it is always necessary to show the marked weight. A large cross (X) shall be placed in the net column when no test weight is made.

LABORATORY ANALYSIS

When a sample is mailed for laboratory analysis, indicate the analysis requested by placing an "X" in the applicable column heading; e.g., if total solids and fat are requested, place an "X" just beneath the words "Solids" and "Fat". The laboratory section is completed by the laboratory. If no analysis is required, a large cross shall be drawn across the entire laboratory section.

Fee - Indicate "Contract" if service rendered on resident basis.

Signature - Resident and fee inspectors and graders sign as "Official Inspector." When a laboratory analysis is required, the chemist will sign in the space provided for him and record his fee and expense in the space to the left of his signature.

REMARKS

The section "Remarks" is to be used for information not otherwise on the certificate. Make the certificate as informative as possible.

Whenever egg products are produced from edible shell eggs of other than current production, the following statement shall appear: "Produced from edible shell eggs of other than current production."

The information required for liquid shipments, such as temperature, seal numbers, time of departure should be put in this space.

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In case the certificate is a loading certificate, including laboratory analysis from another certificate, the number of the certificate from which the laboratory results were obtained should be listed.

Prepare the report, preferably with a typewriter and sign the original in ink or indelible pencil. Each copy shall bear the carbon copy signature of the original, or shall be initialed. Issue in numerical order. When an excessive number of corrections are necessary, mark the original and copies "VOID". List voided certificates on Form PY-206 and forward the original, together with the copies of other certificates, to the State Supervisor.

B. Preparation and Distribution of Form PY-200 by Type of Operation.

1. In plants where eggs are broken and frozen on same premises or adjacent freezer.

a. Issue separate certificates covering product eligible to bear the inspection mark and which is identified. These certificates are to be issued upon request of the applicant.

b. Issue separate certificates covering product eligible to bear the rectangular mark and which is identified. These certificates are to be issued upon request of the applicant.

c. Issue separate certificates, upon request, to cover product eligible to bear the shield inspection mark or rectangular mark but not identified. The certificate shall state that the product was not officially identified.

(1) Distribution:

(a) Prepare an original and five copies.

(b) Original and one copy to the applicant. Two additional copies may be furnished to the applicant upon his request.

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(c) One copy to the State Supervisor weekly.

(d) Attach one copy of each PY-200 issued to the original of PY-206, which is mailed to the State Supervisor at the end of each month.

(e) Attach one copy of each PY-200 issued to the copy of PY-206, for your file.

2. In plants where liquid eggs are shipped to an official drying or packaging plant:

a. Prepare an original and five copies for each shipment.

b. Tank and enclosed trucks shall be sealed, at both the top and draw-off outlet. The seals shall be those that can be fastened by either string or wire and have a number imprinted thereon for identification purposes. Seals shall be controlled by the resident inspector. Report the following on the certificate: The seal numbers of truck, license number of tanker or truck, number of containers, pounds of liquid, temperatures of liquid at time of departure, the time of departure, and the exact hours (7:00 a.m. to 4:00 p.m., 5/21) during which liquid egg meat was produced.

c. The original and one copy of the certificate shall accompany the load in a sealed envelope, addressed to the inspector at destination.

d. The inspector at destination shall handle the certificates as outlined in IX-B-3(a,b).

e. The copies of the certificates shall be distributed in the same manner as provided in IX-B-1-c(1).

3. In plants where liquid eggs are frozen or dried and packaged but not broken:

a. Record the following on the original and copies of the Form PY-200, which accompanied each load received at the plant.

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(IX-B-3 cont'd)

(1) Time of arrival.

(2) Temperature of the liquid at arrival.

(3) Number of containers.

(4) Seal numbers, if any. The tanker must be sealed with a numbered seal, corresponding to that listed on the certificate accompanying the load in order for the final product to be officially identified.

(5) The inspector's initials.

b. Distribution:

(1) Attach original to grader's file copy of Form PY-203, issued at the packaging plant.

(2) Furnish one copy to management of the packaging plant.

c. After the product is packaged and frozen or dried, the inspector may, upon request, issue Form PY-200 in an original and five copies.

(1) Distribution:

(a) Original and one copy to the applicant. Two additional copies may be furnished upon request of the applicant.

(b) One (1) copy to the State Supervisor.

(c) Attach one copy of each PY-200 issued, to the original or PY-206.

(d) Attach one copy of each PY-200 issued, to the inspector's copy of PY-206.

4. In plants where liquid eggs are shipped as liquid eggs to consumer or non-official plant:

(IX-B-4 cont'd)

a. Prepare, upon request, Form PY-200 in an original and five copies. Identify the product by type of product and volume. When product is shipped by tank truck, record truck number and seal, if load is sealed, temperature of liquid and time of departure.

b. Distribute certificates as in IX-B-3-c(1) above.

5. Certificates (PY-200) covering individual shipment: Whenever the company, at which the inspector is stationed, desires a certificate (PY-200) to cover a specific shipment, and the inspector is unable to show the exact USDA or plant lot numbers on the certificate, it will be necessary for him to make a second inspection. The date of issuance of the certificate shown in the upper right hand corner will be the date of the second inspection. The inspector should drill the square root of the number of containers in the lot up to 1,000, and three percent of the containers in the lot in excess of 1,000. Under previous package remarks, state whether product is identified with "USDA Inspected Egg Products" shield identification, or with "Egg Products" rectangular identification. Complete remainder of certificate, except laboratory analysis.

C. Voiding or amending a certificate.

1. Voiding a certificate. Never destroy the original certificate. If too many errors are made in executing a certificate, the word "VOID" may be written diagonally across the face of the certificate. Such voided original certificates are to be attached to Form PY-206, listed on same, and mailed to the State Supervisor.

2. Minor errors. All minor errors which are corrected before the certificate is issued, shall be initialed by the grader.

3. Amended certificates. Amendments must be dated and signed by the grader. When a minor error is discovered after the certificate has been released and it is difficult to recover the original, it sometimes becomes necessary to issue an amendment to correct the original certificate. Amendments are used to correct minor errors such as the fee or name of the applicant. Amendments are also issued when a

(IX-C-3 cont'd)

major error exists and all copies of the certificate can not be recovered, provided all interested parties can be supplied copies of the amendment. Amendments are made in memorandum form on an official letterhead.

(To be Attached to Egg Products Inspection Certificate)

TO WHOM IT MAY CONCERN: _____ (Date)

Egg Products Inspection Certificate, No. B-8246, dated June 30, 1959, Applicant: Whatso Egg Co., covering grading at Imso Cold Storage, Daily, Arkansas, is amended as follows:

Original Certificate

No. of containers in lot 1200
amended to:
No. of containers in lot 1089

Signed _____
Grader

X INEDIBLE EGGS

A. All official identification shall be removed or obliterated from cans used for inedible eggs. The cans should be labeled as unfit for human food.

B. An ample amount of denaturants shall be placed in the inedible liquid containers prior to beginning operations unless written permission is obtained to handle by other methods. Merely labeling inedible eggs is no substitute for denaturing. Satisfactory denaturants include:

1. Lamp black or powdered charcoal, when mixed into product before freezing.

2. Kerosene pine oil, fuel oil, cresote, petroleum distillate, or fish oil when added outside of the breaking room.

Products containing these substances may not be placed in any room where edible products are handled or stored. The use of volatile substances is not recommended.

Egg Products Inspectors Handbook

XI USED CONTAINERS

Egg product may be packaged in used 30-pound tin containers and identified when the following conditions are met:

A. Containers are not extensively dented.

B. Lacquer inside of each can is practically intact.

C. Inside of can is free from rust.

D. Bottom seams are not damaged to the extent that adequate cleaning is impossible.

E. Each can and cover is clean.

F. Seams are not ripped or split.

G. Either new lids, or lids which are as good as new, shall be used. (The can shall be capable of being sealed sufficiently tight so that filth cannot enter the containers after the lid is in place.)

When used containers do not meet the requirements of XI-A through F, they may be used when lined with an approved liner.

H. All old markings are removed, or covered with a label.

I. The liquid egg is immediately frozen. No liquid may be held in new or used 30-pound tin containers.

J. The determination that the plant has complied with all of the above conditions shall be the responsibility of the resident inspector. It is desirable that each resident inspector clear with his supervisor prior to identifying any product packaged in used containers.

K. It is recommended that special can-washing facilities be installed. Ample light (at least 50 foot candles) is to be available to determine the adequacy of the cleaning operation.

XII SANITATION

Sanitation of the plant is discussed in the Regulations. Certain aspects need further emphasis.

Egg Products Inspectors Handbook

(XII cont'd)

A. Personnel. All resident egg products inspectors are to wear clean white uniforms and head coverings when on duty. Street clothes are not satisfactory. Personal hygiene is important, he should set an example for other plant personnel.

B. Equipment. Plant facilities and equipment were approved by the State, Area or National Supervisor. Any faulty equipment, necessary or proposed changes in equipment or facilities, should be called to the attention of the immediate supervisor. The equipment should be routinely checked and if worn so that proper cleanup and sanitation is not possible, the supervisor should be informed so that corrective steps can be taken.

When mechanical methods of breaking shell eggs are used, sanitation measures apply the same as if hand breaking operations were employed. These sanitation measures should incorporate all those applicable to hand breaking methods but not necessarily limited to such requirements.

C. Operations. Form PY-203 should be completed as a check on daily operations and sanitation. In addition, other things should be observed before or during the rounds of the plant.

1. Air circulation. Filters should be checked and if dirty, be replaced. Fan blades collect dirt and should be cleaned periodically. When portable fans are used within the room, they should be placed so that they do not interfere with the breaking operation. If off odors persist in the room, the supervisor should be notified so that corrective action can be taken.

2. Kitchen.

a. Sanitizing solution. If quaternary ammonium compounds are used, the equipment must be rinsed with clear water prior to reuse.

Chlorine concentrations shall be checked, as required. Starch-iodine test papers are not satisfactory as a sole means to determine the chlorine concentration. If test papers are used, at least one determination each day should be made chemically with some type of test kit and these results compared with the results from the paper strips.

Egg Products Inspectors Handbook

(XII-C-2 cont'd)

In order for proper sanitation to occur, the equipment should be left in the sanitizer at least three (3) minutes. Quick dipping is not satisfactory. If autoclaved, the equipment should be exposed to 15 pounds of steam pressure for 15 minutes.

Individual equipment washing by breakers shall not be permitted, except in the case of machines where the operator cleans and sanitizes the machine after breaking a loss egg.

b. Sponges or brushes shall be properly aired when not in use. Foul smelling sponges or brushes shall be replaced. Stainless steel sponges may only be used on equipment not coming into contact with the product. They shall not be used during processing operations.

So-called abrasive cloths shall be treated the same as stainless steel sponges. These cloths tend to flake-off, and could result in contamination of the product. Plastic 'tuffy' type pads may be used to remove adhering particles of material.

It has been observed that if proper prerinsing and washing is done each time the equipment is in the kitchen, most of the cleaning 'crutches' are not needed.

c. Clean equipment shall be properly drained and aired. It shall not be nested. If adequate shelf storage is not available, the State Supervisor shall be informed. Cans and pails are not acceptable for storing separators or other small equipment.

3. Transfer room.

a. Sources of off-odors shall be investigated.

b. Proper segregation of leakers shall be done here, not in the breaking room. Case leakers shall be discarded.

c. If excessive loss eggs are prevalent, the shell eggs shall be candled on an individual egg basis. The company shall have knowledge of the loss in each lot prior to sending the lot to the transfer room.

Egg Products Inspectors Handbook

(XII-C-3 cont'd)

d. Chlorination of shell eggs shall be used only on eggs previously washed or cleaned, or on those meeting cleanliness required of A quality shell eggs. For hand-breaking operations, the eggs must be properly dried before breaking. On machines, excess moisture must be removed prior to breaking.

e. Incubator reject eggs are loss eggs and shall be denatured.

4. Breaking room.

a. Loss eggs are defined in §55.79(g-4)(Amended) and shall be handled according to §55.77(c) and §55.83(j,k,l,m, and n). Numerous mixed rots have odors for only a brief period of time. When a mixed rot is encountered at the breaking table, it must be discarded regardless of odor. Such eggs should not be reexamined for odor at the inspection table, but rejected without further question.

b. Loss eggs on breaking machines shall be handled as follows:

(1) The trays on the breaking machine will be identified as follows:

(a) The tray guarding the knives at the rear of the machine is called the "Knife Guard Tray."

(b) The "L" shaped tray below the air jet is called the "Recovery Tray".

(c) The large tray which receives whole egg from ruptured yolks is designated the "Whole Egg Tray."

(2) When an unsatisfactory egg is encountered, the operator should inspect all eggs currently in the separator cups to determine if there are other loss eggs present.

(XII-C-4 cont'd)

(3) When the following types of eggs are encountered by the machine operator, she will immediately shut off the machine, remove the separator containing the egg and place the contents of the separator in an inspection cup and stand the separator lip downward in the cup. The tray containing the cup and separator will be taken to the kitchen for cleaning and sanitizing and the egg discarded. The machine will be completely washed and sanitized. All liquid pails and other containers will be inspected for possible contamination.

(a) Black Rots.
(b) Rots where the shell explodes.

(4) Upon encountering the following types of eggs, the operator will immediately stop the machine, remove the separator and the egg and place both in an inspection cup. She will remove the recovery tray and replace it with a clean tray and inspect by smelling all other machine trays and liquid pails.

(a) Mixed Rots.
(b) Green Whites.
(c) Crusted Yolks.
(d) Sour Eggs.
(e) Musty Eggs.

(5) Cups containing the following types of eggs may be left on the machine, but the contents must be dumped from the separator into an inspection cup.

(a) Diffused Blood.
(b) Blood Rings.

(6) The following types of eggs will be handled by tripping the separator so that it will deposit the contents into an inspection cup in the normal manner.

(a) Blood Spots.
(b) Meat Spots.

(XII-C-4 cont'd)

Removal of blood or meat spots will be done at the inspection table.

(7) Loss eggs, as determined by the operator of the machine, shall be discarded without further question. Odorless loss eggs may be collected in a container marked inedible, at the machine. Any other loss eggs must be promptly removed from the breaking area.

c. If the washer on the breaking machine is not being used, the brushes should be raised so that the eggs do not drag through them. The machines should be carefully checked for sanitation, especially when the washers are not being used. On breaking machines, care should be used to prevent empty shells from getting into the liquid product.

d. The operator at the inspection table shall be provided with a container of sanitizing agent in which to dip her spoon. If her equipment comes in contact with inedible product, the same procedure as used for other breaking equipment should be followed. It shall be washed and sanitized.

e. Belts carrying eggs shall be maintained in a clean and sanitary manner. In order to prevent musty odors, the belts should be raised so that they can air and dry when not in use. Belts should be clean and be sanitized at the start of daily operations and during the noon break. At the beginning of the daily operation of a machine equipped with a chlorinator, one complete revolution of the feed line should be made with chlorine spraying, before feeding of the egg is started.

f. In plants with air conditioners, or during extremely cold weather, it may not be possible to run the power exhaust continuously. If an objectionable odor develops, the exhaust and intake fans must be operated until this odor is removed from the processing area.

5. Liquid handling.

a. The definition of stabilized egg for purposes of §55.85 is that egg from which sugars have been removed. Eggs

(XII-C-5 cont'd)

to which other ingredients have been added are not considered to be stabilized for the purpose of temperature requirements. When freezers are such that they cannot comply with §55.85(c), follow the suggestions in VI-B-5. Also see §55.85(d), amended.

b. Containers for the liquid shall be inspected for cleanliness, whether it is a 30-pound can, a stainless steel tank or a tank truck. Provisions shall be made so that all 30-pound cans can be washed or given a water spray prior to use.

XIII EXPLANATION OF FORM PY-203, "DAILY REPORT OF PLANT OPERATION"

When the old form of PY-203 is used, it will be necessary for the inspector to amend the forms according to the example included herein.

Plant Name: Insert the name of the plant at which the inspector is stationed.
Plant Number: Insert plant number, not grader's number.
Address: Insert the address of the plant at which the inspector is stationed.
Resident Egg Products Inspector: Insert the resident inspector's name in this space.
Date: Insert the month and year covered by this report.
Code: Insert either the company code or day of year.

Item 1. Means premise outside the building and all rooms within the official plant other than breaking room, drying room, candling room, and rest room. Requirements are listed in §55.75 (b).

2. Requires night clean-up and periodic attention during working hours. §55.75(c),(d),(e),(m),(n), and §55.100.

3. Requires night clean-up and orderly operations during candling operations; refers principally to room, not equipment. See §55.75 and §55.79.

4. Requires night clean-up and constant attention during processing operation. See §55.75.

Egg Products Inspectors Handbook

(XIII cont'd)

5. Means after clean-up; when not in use. See §55.77(m); 55.83(z); and 55.99.

6. Means all equipment, including lines and vats. See §55.77 (a) and (m); §55.83(u),(v),(w),(x),(y),(z),(aa),(dd),(ee).

7. Means rooms where egg meat is frozen. The temperature shall be recorded for the areas of each room where circulation is least effective. See §55.87 and 55.88.

8. Means the flow of air directed mechanically to eliminate warm pockets in each room where product is freezing. See §55.87.

9. Each can of egg meat shall be spaced until frozen so that air can circulate freely. See §55.88(c).

10. Means belt conveying shell eggs to breakers. See §55.83(c) and (w) and 55.99. Are sprays on? Squeezees adjusted?

11. Determine the adequacy of segregation; that is, the removal of dirties, eggs other than domesticated chicken eggs and leakers by periodically observing the breaking belt, or in shell egg buckets, just prior to breaking. Determine the loss removal by observation at the inspection table and/or candling 100 eggs which have been segregated for breaking. See §55.79(g) and 55.81(b). Storage eggs must be broken separately. Dirty dented checks may not be broken. If more than an occasional loss egg (other than blood and undetectable green and sour) enter the room, the segregation is unsatisfactory. Such lots must be fully candled.

12. Means are "loss" eggs removed prior to entering breaking room? Are they in trays? See §55.79(g)(3) and §55.39.

13. Means is each egg examined adequately for odor, appearance and contamination. See §55.83(g),(h),(i),(m),(o), and §55.79(g)(3). Each operator shall be observed as well as liquid eggs at the receiving station.

14. Means any receptacle for catching liquid egg accidentally missing cups or troughs. See §55.83(o).

Egg Products Inspectors Handbook

(XIII cont'd)

15. Inedible does not include blood spots and blood rings. See §55.83(i),(j),(k), and (l). All eggs in the cup, canadian tray and drip tray must be discarded whenever any loss egg is encountered, other than bloody whites and blood rings. There is no degree in loss.

16. All egg meat shall be checked by a person holding a license or a limited license. See §55.83(h) and (m).

17. Temperature to be taken of liquid at draw-off vat. See §55.85(b).

18. Temperature should be recorded for both whole egg and rectangular. Suggest marking cans so no question is raised with respect to time element. This must be an accurate reading. See §55.85(c), (c-1), and (f).

19. Determine the strength at time of preparation, need for replacement, frequency of replacement, length of time equipment subjected to solution, and approval of compound. See §55.99; 55.83(t); and 55.77(g).

20. Refers to small equipment such as trays, cups, separators, and pails, see §55.83(4).

21. See §55.83(z), (aa); and §55.99 for varied requirements.

22. Include drums, vats, cans, and tank wagons. See §55.83 (cc),(dd),(ee), and §55.99(h).

23. Pour at least one and preferably two cans from the first churn of each system each day to determine proper seating of strainers. This means each time the strainer facilities are assembled. After drawing off the liquid egg into the can, the container should be allowed to stand for at least 15 minutes before the pour test is performed.

24. All labeling on containers bearing the USDA official identification requires approval; no wording may be added or deleted without additional approval. All labeling and stamps shall be legible. See §55.35; 55.36; 55.37; 55.38; 55.39; 55.40; 55.42; and 55.43.

Egg Products Inspectors Handbook

(XIII cont'd)

25. Refers to egg meat from rejected cups, leaker trays, shell egg buckets, and inedible frozen. See §55.77(b),(c),(d); and §55.83(j),(k),(l),(m),(n),(p), and (11).

26. Determine length of time first egg liquid is broken until it reaches freezer for entry under 'start'. See §55.85.

26a. When liquid eggs are subjected to heat treatment, record on the reverse or bottom of the form:

1. Temperatures of liquid egg while pasteurized (range) (may be taken from recording chart) _____

2. Temperatures of heating medium. _____

3. Temperatures of liquid egg 1-1/2 hours after pasteurization. _____

26b. When liquid egg is held for shipment or pasteurization, record the temperature of the liquid egg 1-1/2 hours after breaking in the right half of the space for the type product which is held.

27. See §55.81.

28. Means regular removal from candling and transfer room; need not be denatured, provided shell eggs are destroyed or placed in channels for other than human food. See §55.77(c) and 55.79(g).

29. Applies to the draw-off area, unless plant has separate room. See §55.75; 55.76; and 55.77.

30. See §55.100(c),(d),(e),(f),(g), and (h).

Balancing Scale: Refers to scale used in weighing containers.

A. Is self-explanatory.

B. An estimate is sufficient.

C. A close estimate is sufficient.

D. Report exact number of pounds.

Egg Products Inspectors Handbook

FORM PY-203 (3-9-55) U. S. DEPARTMENT OF AGRICULTURE AGRICULTURAL MARKETING SERVICE	PLANT NAME	PLANT NO.
EGG PRODUCTS INSPECTOR DAILY REPORT OF PLANT OPERATION	ADDRESS	
RESIDENT EGG PRODUCTS INSPECTOR	DATE	CODE

IMPORTANT: *Give exact figures where applicable. Mark √ for "Yes" and X for "No". Four or more readings required for each factor.*

ITEM	START	INDICATE HOUR CHECK MADE		
1. Premises, general sanitation				
2. Rest Rooms, general sanitation				
3. Candling room, general sanitation				
4. Breaking room, general sanitation				
5. Were pumps and lines left dismantled?				
6. Was equipment sanitized and drained prior to use?				
7. Liquid egg product freezer temperature				
8. Adequacy of air circulation in freezer				
9. Were containers adequately spaced in freezer? Shield				
Rectangular				
10. Is Shell Egg Conveyor belt Clean, Dry?				
11. Loss per 100 eggs as presented for breaking				
Dirties per 100 eggs as presented for breaking				
Dux eggs per 100 eggs as presented for breaking				
Leakers per 100 eggs as presented for breaking				
12. Are leakers presented properly for [redacted] breaking				
13. Adequacy of egg smelling and examination at breaking time				
14. Are drip trays emptied regularly				
15. Were hands washed and complete clean set of brsaking equipment				
obtained after breaking inedible egg?				
16. Adequacy of egg smelling at churn				
17. Liquid egg temperature [redacted] at draw off vat				
18. Liqnid egg temperature /20" after entering freezer: Whole-Rectangular				
19. Adeqnacy of sterilizing solution				
20. Clean eqnipment inverted and drained				
21. Adequacy of sterilizing D-tanks, pails, strainers				
22. Were cans (liquid eggs) and lids properly cleaned?				
23. Pour Test; Each System: Whole				
Yolks				
Whites				
Egg Products				
24. Were egg products properly marked?				
25. Were inedible liquid eggs denatured or disposed of aatiafactorily?				
26. Time breaking to freezer: Whole				
Yolks				
Egg Products				
Rectangular				
27. Temperature of wash water for dirties				
28. Were inedible shell eggs disposed of satisfactorily				
29. Packaging room, general sanitation				
30. Health and Cleanliness of help (Uniforms - Nets - Hands)				
BALANCING SCALE: a. Breaking Room				
b. Packaging Room				

A. Number of cases eggs processed		E. Number of packages and weight dried produced	
B. Number of dozen shell eggs denatured		F. Rectangular Dried	
C. Number of pounds liquid denatured		G. Number of pounds dried denatured	
D. Number of pounds shell wringings			

	PRODUCTION RECORD		FINAL INSPECTION			TEST WEIGHING (NUMBER OF CANS WEIGHED)		
	CANS	POUNDS	DATE DRILLED	NUMBER	CONDITION	GROSS	TARE	NET
Whole Eggs								
Yolks, plain								
Whites								
Egg Products								
Total								
Rectangular								

Breaking Operations _____ A.M. _____ P.M. Supervisor on Duty _____ A.M. _____ P.M.

Use Reverse Side for Remarks

FORM PY-203 (REVERSE)

1. Did you receive today, not previously approved, a new:

	YES	NO
A. Label	☐	☐
B. Lithographed can	☐	☐
C. Cover	☐	☐

If "Yes," to A, B or C, submit to State office.

2. Did you receive today a new:

A. Insecticide	☐	☐
B. Germicide	☐	☐

If "Yes," to A or B, give name and formula:

_____

3. Do you need additional:

A. Forms	☐	☐
B. Supplies	☐	☐

If "Yes," to A, give form number and quantity.

_____

_____

_____

Egg Products Inspectors Handbook

XIV PREPARATION AND DISTRIBUTION OF EGG PRODUCTS INSPECTORS REPORT, FORM PY-206

A. Preparation of Form PY-206.

1. Each inspector is required to execute the Egg Products Inspectors Report, Form PY-206, on a daily basis with respect to the volume processed and a record kept of volume received.

   a. Each certificate issued shall be listed in numerical order on the report. Show if PY-200 or PY-225.

   b. Form PY-206 shall be executed each month regardless of whether or not product is processed.

   c. A completed example of Form PY-206 appears on Page 38.

B. Distribution of Form PY-206.

1. Mail the original and two copies to the State Supervisor's office no later than the third work day following the close of the month. Attach to each PY-206, one copy of each certificate issued. When the applicant on a certificate is a Federal Agency, the inspector shall attach two copies. One copy of each PY-206 and each certificate is to be retained by the grader.

2. The State Supervisor shall mail two copies to the Area Supervisor who, in turn, shall mail one copy to the National Office.

3. In those states that serve as their own collection office, only an original and one copy need be mailed to the State Supervisor who, in turn, will mail one copy to the Area Supervisor, who in turn will mail it to the National Office.

C. Explanation of Form PY-206.

1. Name of Plant: Shall be the same as one appearing on the contract.

2. Address: Is the address of the processing plant.

Egg Products Inspectors Handbook

(XIV-C cont'd)

3. Plant Number: Is the number of the plant; not the grader's number.

4. Month: Is the calendar month covered by this report.

5. Year: Is the calendar year covered by this report.

WEIGHT EGG PRODUCT PROCESSED:

6. Shield: List the total pounds shield quality product processed each day, whether identified or not.

7. Rectangular: List the total pounds of rectangular quality product processed each day, whether identified or not.

8. Inedible: List the total pounds liquid denatured in breaking room and shell eggs destroyed as inedible and inedible extracted from egg shells.

PROCESSING REPORT ISSUED:

9. Date:
10. Certificate No.
11. Weight:

List each processing certificate issued in numerical order. Show type of certificate used (PY-200 or PY-225). List voided certificates also. Code EP precedes PY-200 certificate numbers and Code I precedes PY-225.

12. Subtotal (add a, b, and c): Total figures in Blocks a, b, and c. If the company does not keep a record of the weight of liquid dried, it is necessary to multiply the weight of dried whole eggs by 3.7; the weight of dried yolks by 2.2; and the weight of dried whites by 7.5; and add the resultant total to the figures in Blocks a, b, and c, to obtain the correct figure subject to administrative charge.

13. Liquid Weight Received for Drying: If plant also produces dried egg solids, insert total of liquid weight received into the plant in liquid form; it is not the figure in Block d.

14. Total Liquid Weight (Subject to Volume Charge: Add Nos. 12 and 13.

Egg Products Inspectors Handbook

(XIV-C cont'd)

15. Administrative Charge: Use the Regulations (amended) to determine figure to enter herein.

16. Signature of Plant Manager: The signature must be one of a responsible official of the company.

17. Signature of the Grader: Sign your name with ink or indelible pencil; typing is insufficient.

18. Dried: If the plant dries eggs, list the total weight dried egg solids produced each day, including product eligible for shield, rectangular and "off-quality", such as dust-house and burnt powder.

DRIED EGG SAMPLING REPORT RECORD

19. Date)
)
20. Number:) List each sampling report issued.
)
21. Weight:)

If you have insufficient space to list each processing report or sampling report, use a second form and mark it "continuation". If no dried egg sampling report is issued, the inspector may block out lines: "Dried Egg Sampling Report Record," and use spaces 19, 20, and 21 to continue listing the processing reports issued.

XV COMPOUNDS

§55.77(g) of the Regulations reads as follows:

"Only such germicides, insecticides, rodenticides, detergents, or wetting agents, or other similar materials may be used as will not contaminate or deleteriously affect the edible product. The use of such compounds shall be in a manner satisfactory to the Administrator."

Whenever the company at which the inspector is stationed, proposes to use detergents, germicides, insecticides, or rodenticides within the official plant which have not been approved by this Branch, he shall arrange to have the labeling on the containers forwarded to the National Office.

Egg Products Inspectors Handbook

FORM PY-206
(9-15-58)

U. S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISION

EGG PRODUCTS INSPECTOR'S REPORT

NAME AND ADDRESS OF PLANT *(City and state)* 1. & 2.

Super Duper Egg Company
Glory, Missouri

PLANT NO. 3. 2678

DATE *(Month and year)* 4. & 5. January, 1955

DATE	WEIGHT OF EGG PRODUCT PROCESSED (LBS.)				PROCESSING REPORT ISSUED		
	6. SHIELD	7. RECTANGULAR	8. INEDIBLE	DRIED	9. DATE	10. CERTIFICATE NO.	11. WEIGHT *(Pounds)*
1					16	EP 23865	30,000
2					22	EP 23866	36,000
3	11,600	300	30		29	EP 23867	33,000
4	30,000	360	60				
5	25,560	240	30		30	EP 23868	VOID
6	10,350	180	60				
7	21,500	420	30				
8							
9							
10	5,300	90	10	n/a			
11	19,500	240	30				
12	17,490	240	60				
13	24,700	390	90				
14	10,300	210	60				
15							
16							
17	6,240	120	30				
18	10,500	180	60				
19	43,680	630	120				
20	9,470	180	120				
21	10,560	240	30				
22							
23							
24	9,090	180	30				
25	23,390	270	10				
26	6,450	210	10				
27	16,700	360	90		18. DRIED EGG SAMPLING REPORT RECORD		
28	20,900	390	120		19. DATE	20. NUMBER	21. WEIGHT *(Pounds)*
29							
30							
31	13,740	900	100				
TOTAL	a 347,020	b 6,330	c 1,180	d		n/a	

12. 1. Total Weight *(Columns a, b and c)*	354,530
13. 2. Liquid Weight Received For Drying *(Column d)*	- - - -
3. TOTAL LIQUID WEIGHT - Subject to Volume Change *(Items 1 and 2 above)* 14.	354,530
15. 4. ADMINISTRATIVE CHARGE	$75.00

16. *I hereby certify that the weights stated above are the weights of product, processed and received.*

John W Nelson
(SIGNATURE OF PLANT MANAGER)

17. *I hereby certify that the weights of product processed and received, as stated above, are correct to the best of my knowledge, and the product officially identified is as marked.*

Harry Doe
(SIGNATURE OF INSPECTOR)

Egg Products Inspectors Handbook

XVI EXAMPLES OF CERTIFICATES

A. Some examples of how certificates are to be completed are included as an aid to the inspector.

Sample A - Frozen product.

Sample B - Frozen product where laboratory analyses are done at the plant level.

Sample C - Liquid product (in tankers).

B. Explanation of Form PY-225, "Poultry Products Grading Certificate:

1. Obtain from the Supervisor.
2. Supervisor's headquarters.
3. Date on which grading performed.
4. The person paying for the service rendered.
5. If same as 4, show "Same" - otherwise, name and address.
6. Name and address of receiver.
7. As in example - Date and acceptance mark.
8. Kind of product and description (frozen whites, yolks, etc.).
9. Number, Kind, and size of packages.
10. N/A
11. Indicate whether shield or rectangular.
12. Requirements as to institutional contract grading; i.e., meets "State of Illinois requirements."
13. Enter fee for each item graded and show "U" if based on Units and "T" if based on time.
14. Must be signed in ink or indelible pencil.
15. Enter word "Contract" on fee line if resident grading.
16. Insert address of collection office if fee grading.

Egg Products Inspectors Handbook

FORM PY-200 a (6-20-56)
U. S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISION

COPY

EGG PRODUCTS INSPECTION CERTIFICATE

DATE: May 22, 1959

ISSUED IN COOPERATION WITH: Nebraska Department of Agriculture

SAMPLE - A

TO: APPLICANT (NAME AND ADDRESS)
Golden Egg Company
Golden, Nebraska

KIND OF PACKAGE: New Lacquered Tin, 30#

PREVIOUS PACKAGE MARKS: None

NAME AND ADDRESS OF SHIPPER OR SELLER 1/
Golden Egg Company
Golden, Nebraska

TYPE OF PRODUCT 1/: Frozen Egg Products

NAME AND ADDRESS OF RECEIVER OR BUYER 1/
Egg Sales, Inc.
Chicago, Illinois

PLACE SAMPLED OR WEIGHED: Golden Egg Company
Golden, Nebraska

SAMPLE ☐ ALL ☒

PKGS. WERE STAMPED WITH: USDA Shield
Plant 000

ORGANOLEPTIC INSPECTION / **WEIGHING REPORT**

LOT NO.	DATE MANUFACTURED 1/	NO. PKGS. IN LOT 1/	NO. PKGS. EXAMINED	ORGANOLEPTIC CONDITION: SATISFACTORY	ORGANOLEPTIC CONDITION: UNSATISFACTORY	TOTAL MARKED 1/	TEST SHORTAGE	TOTAL NET
135	5-15-59	126	5					
136	5-16-59	574	15				1 on 50 cans	
138	5-18-59	300	12					
		1000	32	32	None	30,000	600	29,400

LABORATORY ANALYSES

LOT NO.	SOLUBILITY	PALATABILITY	SEDIMENT	SUGAR	TOTAL SOLIDS	FAT	COLOR	BACTERIA: VIABLE COUNT M PER GM	BACTERIA: DIRECT COUNT M PER GM	E-COLI	YEAST AND MOULD
	(If laboratory analysis is requested - leave blank and laboratory will complete. If no analysis requested, place large "X" over entire section.)										

1/ As stated by applicant or contractor.

NOTICE OF BILL

RETURN PINK COPY WITH REMITTANCE

The amount indicated below is due and payable **AT ONCE** *by money order, check or draft. Payment should* **NOT** *be made in cash.*

MAKE CHECKS PAYABLE TO: AGRICULTURAL MARKETING SERVICE, USDA

MAIL TO: POULTRY DIVISION
U. S. DEPARTMENT OF AGRICULTURE

Insert nothing if you are a resident inspector.

REMARKS

Cans stenciled
Frozen Salt Yolk
10% Salt added
30# Net Wt.
Packed by Golden Egg Company
Golden, Nebraska

Laboratory analyses requested (List them).

I certify that in compliance with the regulations of the Secretary of Agriculture governing the grading and inspection of egg products (7 C. F. R. Part 55) pursuant to the Agricultural Marketing Act of 1946 or any other act of Congress conferring like authority, I examined, for class, quality, quantity, and/or condition, at the time and on the date stated below, the egg products, and that the class, quality, quantity, and/or condition, at said time and on said date, were as stated above.

Ima Grader

FEE $ CONTRACT
EXPENSE $
TOTAL $

5/22/59 (DATE)
Ima Grader (OFFICIAL INSPECTOR)
Omaha, Nebraska (ADDRESS)

LABORATORY WILL COMPLETE

FEE $
EXPENSE $
TOTAL $

(DATE)
(OFFICIAL CHEMIST)
(ADDRESS)

This certificate is receivable in all courts of the United States as prima facie evidence of the truth of the statements therein contained. This certificate does not excuse failure to comply with any of the regulatory laws enforced by the United States Department of Agriculture.

Egg Products Inspectors Handbook

FORM PY-200 a (6-20-56)

COPY

U. S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISION

EGG PRODUCTS INSPECTION CERTIFICATE

DATE: May 22, 1959

ISSUED IN COOPERATION WITH: Nebraska Department of Agriculture

SAMPLE - B

TO: APPLICANT (NAME AND ADDRESS)
Golden Egg Company
Golden, Nebraska

KIND OF PACKAGE: New Lacquered Tin, 30#

PREVIOUS PACKAGE MARKS: None

NAME AND ADDRESS OF SHIPPER OR SELLER 1/
Golden Egg Company
Golden, Nebraska

TYPE OF PRODUCT 1/: Frozen Egg Products

NAME AND ADDRESS OF RECEIVER OR BUYER 1/
Egg Sales, Inc.
Chicago, Illinois

PLACE SAMPLED OR WEIGHED: Golden Egg Company
Golden, Nebraska

SAMPLE ☐ ALL ☒

PKGS. WERE STAMPED WITH: USDA Shield
Plant 000

ORGANOLEPTIC INSPECTION

LOT NO.	DATE MANUFACTURED 1/	NO. PKGS. IN LOT 1/	NO. PKGS. EXAMINED	ORGANOLEPTIC CONDITION: SATISFACTORY	ORGANOLEPTIC CONDITION: UNSATISFACTORY
135	5-15-59	126	5		
136	5-16-59	574	15		
138	5-18-59	300	12		
		1000	32	32	None

WEIGHING REPORT

TOTAL MARKED 1/	TEST SHORTAGE	TOTAL NET
30,000	None	30,000

LABORATORY ANALYSES

LOT NO.	SOLUBILITY	PALATABILITY	SEDIMENT	~~XXXX~~ Salt	~~XXXX~~ Egg SOLIDS	FAT	COLOR	BACTERIA: VIABLE COUNT M PER GM	BACTERIA: DIRECT COUNT M PER GM	E-COLI	YEAST AND MOULD
55	-	-	-	10.0	43.1	-	-	-	-	-	-

1/ As stated by applicant or contractor.

NOTICE OF BILL

RETURN PINK COPY WITH REMITTANCE

The amount indicated below is due and payable **AT ONCE** *by money order, check or draft. Payment should* **NOT** *be made in cash.*

MAKE CHECKS PAYABLE TO: AGRICULTURAL MARKETING SERVICE, USDA

MAIL TO: POULTRY DIVISION
U. S. DEPARTMENT OF AGRICULTURE

Insert nothing if a resident inspector.

REMARKS

Cans stenciled: Frozen salt yolk, 30# Net Wt. 10% Salt added. Packed by: Golden Egg Company, Golden, Nebraska

Analysis determined: Salt; solids.

I certify that in compliance with the regulations of the Secretary of Agriculture governing the grading and inspection of egg products (7 C. F. R. Part 55) pursuant to the Agricultural Marketing Act of 1946 or any other act of Congress conferring like authority, I examined, for class, quality, quantity, and/or condition, at the time and on the date stated below, the egg products, and that the class, quality, quantity, and/or condition, at said time and on said date, were as stated above.

DATE Ima Technician

FEE $ CONTRACT (DATE) Drilled (OFFICIAL INSPECTOR) Ima Technician

EXPENSE $ _____

TOTAL $ _____ Omaha, Nebraska (ADDRESS)

DATE Ima Technician

FEE $ CONTRACT (DATE) Analyzed (OFFICIAL CHEMIST) Ima Technician

EXPENSE $ _____

TOTAL $ _____ Omaha, Nebraska (ADDRESS)

This certificate is receivable in all courts of the United States as prima facie evidence of the truth of the statements therein contained. This certificate does not excuse failure to comply with any of the regulatory laws enforced by the United States Department of Agriculture.

Egg Products Inspectors Handbook

FORM PY-200 a (6-20-56)

COPY

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISION

EGG PRODUCTS INSPECTION CERTIFICATE

DATE: May 22, 1959

ISSUED IN COOPERATION WITH: Nebraska Department of Agriculture

SAMPLE - C

TO: APPLICANT (NAME AND ADDRESS)
Jakes Produce
Snowcloud, Nebraska

KIND OF PACKAGE: Tank Trucks, SS

PREVIOUS PACKAGE MARKS: None

NAME AND ADDRESS OF SHIPPER OR SELLER 1/
Jakes Produce
Snowcloud, Nebraska

TYPE OF PRODUCT 1/ (State which)
Liquid Egg White, Liquid Egg Yolks, or Liquid Whole Eggs

NAME AND ADDRESS OF RECEIVER OR BUYER 1/
Yukon Egg Driers, Inc.
Yukon, Kansas

PLACE SAMPLED OR WEIGHED
Jakes Produce
Snowcloud, Nebraska

SAMPLE ☐
ALL ☐

PKGS. WERE STAMPED WITH: None

ORGANOLEPTIC INSPECTION

LOT NO.	DATE MANUFACTURED 1/	NO. PKGS. IN LOT 1/	NO. PKGS. EXAMINED	ORGANOLEPTIC CONDITION: SATISFACTORY	ORGANOLEPTIC CONDITION: UNSATISFACTORY
N/A	5/21/59 7:00 a.m. to 4:00 p.m. & 5/22/59 7:00 a.m.	Tank Truck to 11:30 a.m.	All	All	None

WEIGHING REPORT

TOTAL MARKED 1/	TEST SHORTAGE	TOTAL NET
30,000	None	30,000

LABORATORY ANALYSES

LOT NO.	SOLUBILITY	PALATABILITY	SEDIMENT	SUGAR	TOTAL SOLIDS	FAT	COLOR	BACTERIA: VIABLE COUNT M PER GM	BACTERIA: DIRECT COUNT M PER GM	E-COLI	YEAST AND MOULD

1/ As stated by applicant or contractor.

NOTICE OF BILL

RETURN PINK COPY WITH REMITTANCE

ORIGIN

The amount indicated below is due and payable **AT ONCE** *by money order, check or draft. Payment should* **NOT** *be made in cash.*

MAKE CHECKS PAYABLE TO: AGRICULTURAL MARKETING SERVICE, USDA

MAIL TO: POULTRY DIVISION
U. S. DEPARTMENT OF AGRICULTURE

DESTINATION

REMARKS: Product covered by this certificate is eligible for USDA Shield Stamp Seal Nos. 10875 & 10876, Trailer Lic. No. Neb. 152875. Loading Temperatures: Product 5/21/59 - 33°, 5/22/59 - 35°F. Temperature at Departure - 35°F. Departure time: 4:15 p.m., 5/22/59.

Time of arrival: 2:25 a.m., 5/23/59 Temperature - 36°F., seals intact at time of arrival.

John Doe

I certify that in compliance with the regulations of the Secretary of Agriculture governing the grading and inspection of egg products (7 C. F. R. Part 55) pursuant to the Agricultural Marketing Act of 1946 or any other act of Congress conferring like authority, I examined, for class, quality, quantity, and/or condition, at the time and on the date stated below, the egg products, and that the class, quality, quantity, and/or condition, at said time and on said date, were as stated above.

Richard Roe

FEE $ CONTRACT — 5/22/59 (DATE) — Richard Roe (OFFICIAL INSPECTOR)

EXPENSE $ _____

TOTAL $ _____ — Omaha, Nebraska (ADDRESS)

FEE $ _____ — _____ (DATE) — _____ (OFFICIAL CHEMIST)

EXPENSE $ _____

TOTAL $ _____ — _____ (ADDRESS)

This certificate is receivable in all courts of the United States as prima facie evidence of the truth of the statements therein contained. This certificate does not excuse failure to comply with any of the regulatory laws enforced by the United States Department of Agriculture.

Egg Products Inspectors Handbook

FORM PY-225
3-1-56

U. S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISION

SAMPLE COPY

No. PY- 2862

POULTRY PRODUCTS GRADING CERTIFICATE

Issued in cooperation with California Department of Agriculture 1.

MARKET Los Angeles, Calif. 2. DATE Oct. 22, 1957 3.

4.

TO Jones Egg Company (Applicant) — 620 River St.,Los Angeles,Calif. (Address)

5. Same (Shipper or Seller) — (Address)

Mt. Sani Hospital (Receiver or Buyer) — 6. 1000 Glendale Dr.,Los Angeles, Calif. (Address)

I certify that in compliance with the regulations of the Secretary of Agriculture governing the inspection and grading of poultry, eggs, and egg products and domestic rabbits pursuant to the Agricultural Marketing Act of 1946 or any other act of Congress conferring like authority, I examined, for class, quality, and/or condition, at the time and on the date stated above, the product, and that the class, quality, and/or condition, at said time and on said date, were as stated below.

This certificate is receivable in all Courts of the United States as prima facie evidence of the truth of the statement therein contained.

This certificate does not excuse failure to comply with any of the regulatory laws enforced by the United States Department of Agriculture.

Packages were stamped with Date and Acceptance Mark 7.

PRODUCT (Class) 8.	NO. AND SIZE OF PACKAGES 9.	MARKED WEIGHT 10.	U. S. GRADE OR QUALITY (Size) 11.	MEETS REQUIREMENTS 12.	FEES 13.
Frozen Whites	45-30 lb. cans, new		Shield	Yes	U. 3.60
Purchase order xyz					
Produced in Plant 9876					

14. Bill Peters (Grader)

15.
TOTAL FEE 3.60
EXPENSE .50
TOTAL $ 4.10

PLEASE REFER TO THIS CERTIFICATE BY NUMBER AND MARKET

NOTICE OF BILL

The amount indicated on the certificate is due and payable *AT ONCE* by money order, check, or draft. Payment should *NOT* be made in cash.

Make Checks Payable To: **AGRICULTURAL MARKETING SERVICE, USDA**

Mail To: **POULTRY DIVISION**
UNITED STATES DEPARTMENT OF AGRICULTURE 16.

No. PY-

FOR PROPER CREDIT PLEASE DETACH AND RETURN THIS STUB WITH PAYMENT

Egg Products Inspectors Handbook

XVII DISPOSITION OF PROGRAM RECORDS MAINTAINED BY RESIDENT GRADER:

A. All program records, except those listed under B, below, may be disposed of one year after the close of each fiscal year:

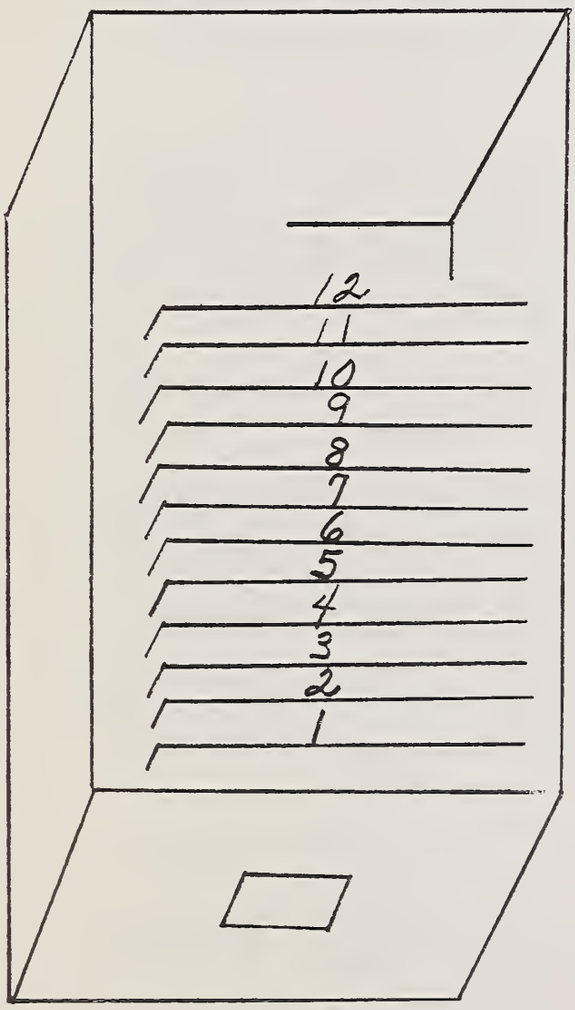
1. PY-117 - Report for Inspection Service Rendered.
2. PY-206 - Resident Egg Products Inspectors Report.
3. PY-212 - Egg Products Inspection Certificate.
4. PY-225 - Poultry Products Grading Certificate.
5. All reports related to each contract covering products inspected for delivery to the Military.

B. The program records listed below may be destroyed when superseded, obsolete, or when no longer active:

1. Federal Standards.
2. Graders' Handbooks.
3. Purchasing Specifications of Government Agencies.
4. Grade Labels and Surveys.

Egg Products Inspectors Handbook

XVIII EXAMPLE OF ORDER IN WHICH RESIDENT GRADERS SHOULD FILE MATERIAL USED IN CONNECTION WITH GRADING PROGRAM:



1. Instructions (Handbook supplemental instructions.)
2. Personnel folder - grader's personal file.
3. Correspondence from State Supervisors, Circuit Supervisor, or Area Office.
4. Monthly reports (PY-206) with copy of certificates issued during month attached.
5. Work sheets, PY-203.
6. Supply of forms used in connection with grading.
7. Army Manual and other related instructions. (If you have been issued one.)
8. Supply of forms used in connection with Department of Defense Grading.
9. Completed Army Orders (all material pertaining to each order should be clipped together).
10. Approved Packaging or Labeling material.
11. Official identification (stamps, etc.) and certificates.

NOTE: Official identification stamp and certificates must be kept in a drawer which can be locked and is accessible only to the grader.

If you wish, Folders 8, 9 and 10 (Army Material) may be kept in a separate file.

Egg Products Inspectors Handbook

XIX PASTEURIZATION

The Regulations (§55.101) state the conditions under which liquid whole eggs, yolks, and mixed whites and yolks may be pasteurized. Sanitary requirements of the pasteurizer shall be followed for all egg products.

In order to determine if the liquid whole eggs have met the requirement of 3 to 4 minutes in the holding tube, it is necessary that certain measurements and determinations are accomplished.

A. Calculations

Attached to this Handbook are Figures 1, 2, and 3. Figure 1 is a diagram for heat treating liquid eggs. Figure 2 is a nomogram to determine the necessary length of the holding tube when you know the flow rate of the product and Figure 3 is a nomogram to determine velocity of flow.

To determine if the liquid is retained 3 to 4 minutes in the holding tube:

1. With a calibrated can, catch 10 gallons of liquid eggs as the eggs come from the holding tube. If there is no accessible place to obtain the egg, it may be necessary to put a valve in the line on the day the check is made. Measure the time period which was required to obtain the 10 gallons. Convert the 10 gallons per minute to gallons per hour. In some cases, it is possible to determine the pounds or gallons of liquid per hour, by the production data.

2. Measure the pipe diameter of the holding tube (inches).

3. Measure the entire length of the holding tube (feet) a 2" elbow is considered to be 6.15 inches long, a $2\frac{1}{2}$" elbow is considered to be 7.97 inches long.

4. With the above measurements, it is possible to determine the minutes in the holding tube by means of Figure 2. Put a dot corresponding to the figure obtained for gallons per hour on line G., put similar dots on lines D and L for diameter and length of holding tube, respectively.

5. According to the Regulations (§55.101(b)), the time in the holding tube shall be not less than 3, nor more than 4

(XIX-A-5 cont'd)

minutes. Hence, on line M, place a dot at 3 and one at 4 minutes. This will give the acceptable range.

Generally speaking, the two things which can be altered are length of holding tube and flow rate (lines G and L).

6. Examples:

a. Suppose the diameter of the holding tube were 2 inches and they pasteurized 3,000 pounds per hour, the holding tube should be 115 to 135 feet long.

b. If the holding tube were 180 feet long and 2 inches in diameter, the flow rate should be from 4,000 to 5,000 pounds per hour. In this case, it is necessary to work backwards - connecting the dots on L and D to obtain a dot on the Pivot line P. Then connecting 3 M through P to G, one gets over 5,000 pounds per hour, and connecting 4 M through P to G, one gets 4,000 pounds per hour.

With holding tubes in excess of 200 feet long, estimates will need to be made, if this chart is used.

B. Operations

1. Sealing the Pump. When the proper flow rate has been established, the controls of the pump used to force the liquid through the pasteurizer and holding tube shall be sealed. If the pump is not equipped with a variable speed device, sealing is not possible.

2. Holding tube. If the flow rate is not correct, and the pump is not equipped with a variable speed, the length of time in the holding tube can be varied by adjusting the length of the holding tube. Use Figure 2 to determine the correct length needed. Note that the egg goes through the flow diversion valve after it goes through the holding tube; hence, the total length of holding tube is that pipe between the pasteurizer and the flow diversion valve.

3. Clean-up. For clean-up purposes, it is not recommended that the variable speed pump be used to circulate the cleaning solution. A high speed pump should be used. The variable speed pump should be dismounted and cleaned by hand.

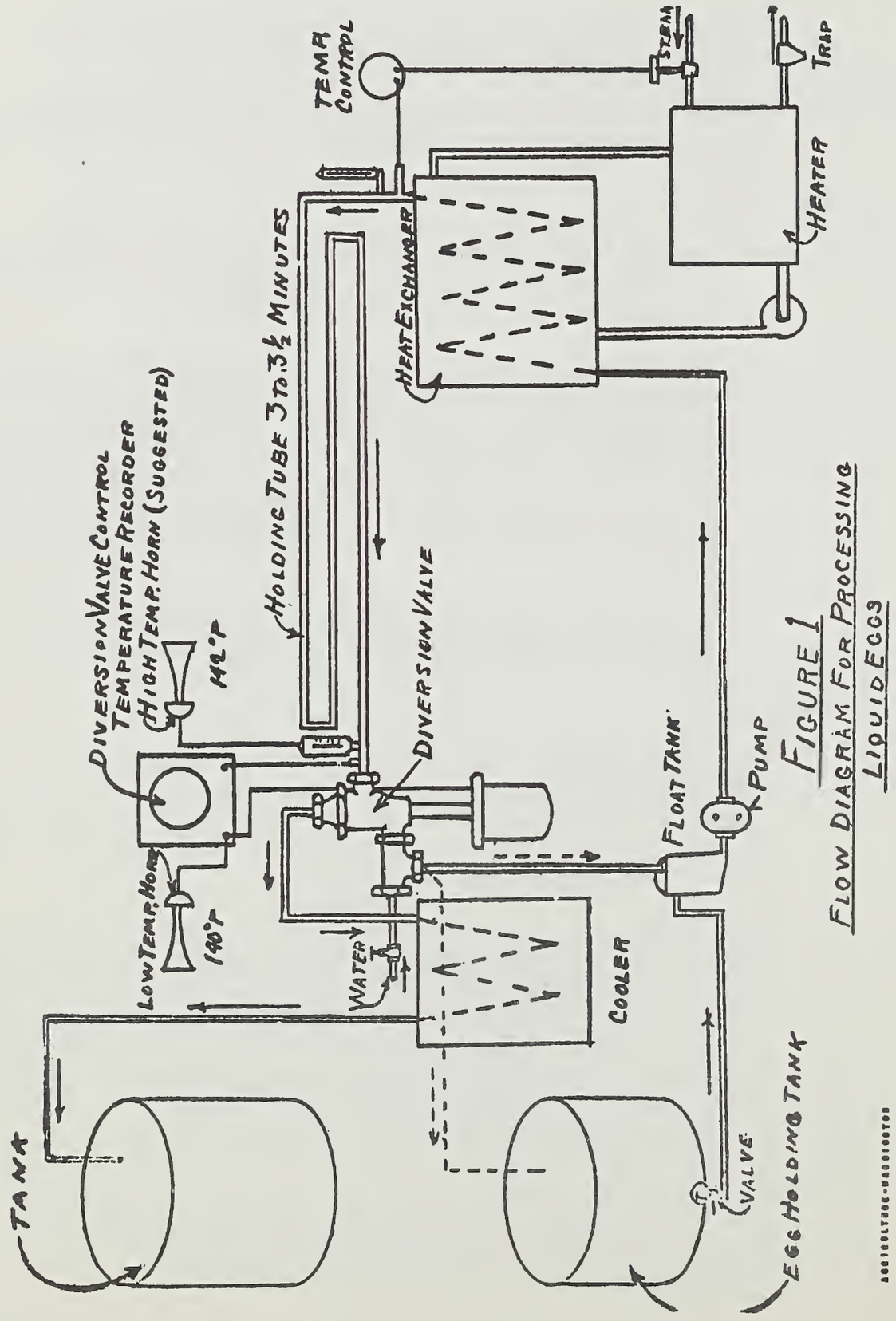


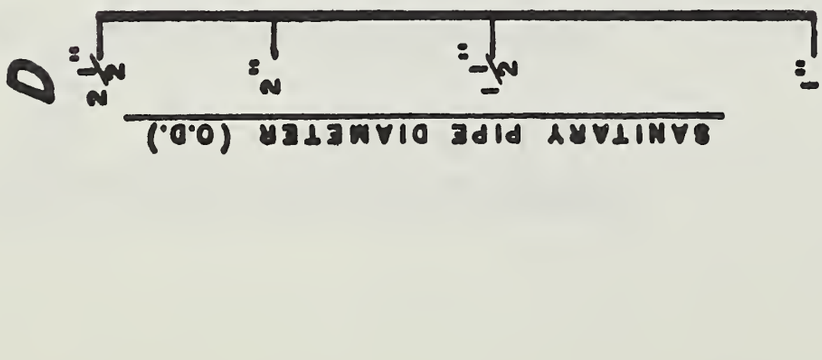
FIGURE 1
FLOW DIAGRAM FOR PROCESSING LIQUID EGGS

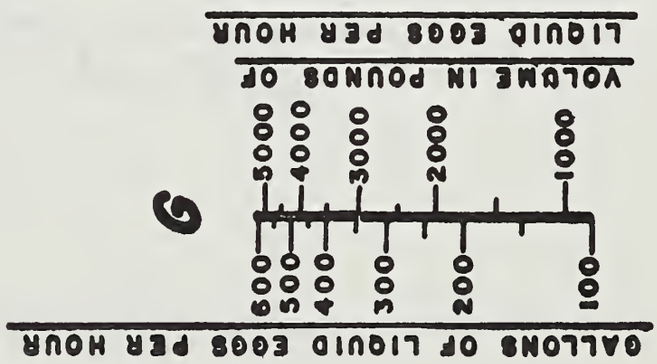
FIGURE 2

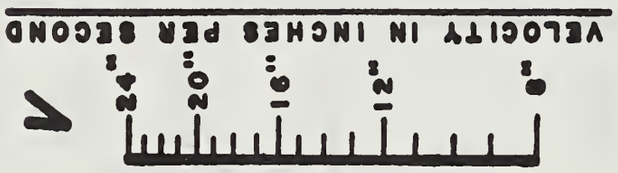
DIRECTIONS FOR USE

To Determine Length of Holding Tube:

a. Locate volume on G
b. Locate minutes of heat treatment on M
c. Draw line from G to M through P
d. Locate outside diameter of pipe on D (measure pipe used)
e. Draw line from D through P at point located by steps a, b, and c above, to L
f. Read length of pipe needed from L







DIRECTIONS FOR USE

To Determine Velocity:

a. Locate on D outside diameter of pipe
b. Draw line from D through G at point representing volume [redacted] to V
c. Read velocity in inches per second on V [redacted]

FIGURE 3

[redacted]

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